

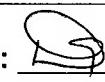
Date: Thursday, 7/13/2006 3:24:37 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)																													
Job Number	: 27890		Part Number	: D2574																													
Estimate Number	: 10534		Drawing Number	: D2574 REV E																													
P.O. Number	: N/A		Project Number	: N/A																													
This Issue	: 7/13/2006	S.O. No. : N/A	Drawing Revision	: E																													
Prsh Rev.	: NC		Material	: N/A																													
First Issue	: N/A		Due Date	: 8/9/2006																													
Previous Run	: 27764		Qty:	20	16	Um: Each																											
Written By	: <i>SP</i> Comment below																																
Checked & Approved By	: <i>JL</i> 06-07-13																																
Comment	: Est Rev E As Per Rev E 06-01-27 JLM																																
<b>Additional Product</b>																																	
<p>Job Number: </p> <table border="1"> <thead> <tr> <th>Seq. #:</th> <th>Machine Or Operation:</th> <th>Description :</th> </tr> </thead> <tbody> <tr> <td>1.0</td> <td>D6101005</td> <td>7075-T7351 8.25X5.0X2.5 </td> </tr> <tr> <td colspan="3"> <p><b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)  7075-T7351 8.25X5.0X2.5  Make from D6101-005 billet for D2574  Ensure that grain is along 5.00" length  Batch No: <i>B 25350</i></p> <p style="text-align: right;"><i>EP/J.G 06/07/21</i></p> </td> </tr> <tr> <td>2.0</td> <td>HAAS1</td> <td>HAAS CNC VERTICAL MACHINING #1 </td> </tr> <tr> <td colspan="3"> <p><b>Comment:</b> HAAS CNC VERTICAL MACHINING #1  Program Batch No. <i>27890</i> Double check by: <i>J.F.</i></p> <p>1-Machine Step №1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  4-Deburr and remove all machining marks  5-Tumble to remove sharp edges.</p> <p style="text-align: right;"><i>J.G/EP 06/07/29</i></p> </td> </tr> <tr> <td>3.0</td> <td>MILLING CONV. </td> <td>CONVENTIONAL MILLING MACHINE </td> </tr> <tr> <td colspan="3"> <p><b>Comment:</b> CONVENTIONAL MILLING MACHINE  Machine keyway as per dwg D2573 &amp; D2574</p> <p style="text-align: right;"><i>J.G/EP 06/07/29</i></p> </td> </tr> <tr> <td>4.0</td> <td>QC2 </td> <td>INSPECT PARTS AS THEY COME OFF MACHINE </td> </tr> <tr> <td colspan="3"> <p><b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE</p> <p style="text-align: right;"><i>J.G/EP 06/07/29</i></p> </td> </tr> </tbody> </table>							Seq. #:	Machine Or Operation:	Description :	1.0	D6101005	7075-T7351 8.25X5.0X2.5 	<p><b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)  7075-T7351 8.25X5.0X2.5  Make from D6101-005 billet for D2574  Ensure that grain is along 5.00" length  Batch No: <i>B 25350</i></p> <p style="text-align: right;"><i>EP/J.G 06/07/21</i></p>			2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 	<p><b>Comment:</b> HAAS CNC VERTICAL MACHINING #1  Program Batch No. <i>27890</i> Double check by: <i>J.F.</i></p> <p>1-Machine Step №1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  4-Deburr and remove all machining marks  5-Tumble to remove sharp edges.</p> <p style="text-align: right;"><i>J.G/EP 06/07/29</i></p>			3.0	MILLING CONV. 	CONVENTIONAL MILLING MACHINE 	<p><b>Comment:</b> CONVENTIONAL MILLING MACHINE  Machine keyway as per dwg D2573 &amp; D2574</p> <p style="text-align: right;"><i>J.G/EP 06/07/29</i></p>			4.0	QC2 	INSPECT PARTS AS THEY COME OFF MACHINE 	<p><b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE</p> <p style="text-align: right;"><i>J.G/EP 06/07/29</i></p>		
Seq. #:	Machine Or Operation:	Description :																															
1.0	D6101005	7075-T7351 8.25X5.0X2.5 																															
<p><b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)  7075-T7351 8.25X5.0X2.5  Make from D6101-005 billet for D2574  Ensure that grain is along 5.00" length  Batch No: <i>B 25350</i></p> <p style="text-align: right;"><i>EP/J.G 06/07/21</i></p>																																	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 																															
<p><b>Comment:</b> HAAS CNC VERTICAL MACHINING #1  Program Batch No. <i>27890</i> Double check by: <i>J.F.</i></p> <p>1-Machine Step №1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  4-Deburr and remove all machining marks  5-Tumble to remove sharp edges.</p> <p style="text-align: right;"><i>J.G/EP 06/07/29</i></p>																																	
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<p><b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE</p> <p style="text-align: right;"><i>J.G/EP 06/07/29</i></p>																																	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
# 06/07/09	20	one part dim "V" 0.240 is 0.220	PA 06.07.29 per Q51042	See Attached Email Acceptable	BB	✓ 06.07.29	PA 06.07.29 per Q51042	06.07.29

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No DQA:  Date: 06/08/09

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 7/13/2006 3:24:37 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 27890

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

2nd 06/08/01 20

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FC 06/08/01 (20)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/08/01 (20)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

el 06/08/01

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 350

LB 06/08/01 (20)

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/08/01 (20)

Job Completion



U 06.08.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD	Work Order:	27890
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	see Attached 8-11-12	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.745	1.745	1.745	1.745		
C	3.495	3.505		3.498	3.500	3.500	3.496		
D	1.745	1.755		1.745	1.745	1.744	1.746		
E	7.990	8.010		8.001	8.003	8.002	8.003		
F	0.490	0.510		0.498	0.500	0.499	0.497		
G	0.257	0.262	DT8683	0.259	0.259	0.258	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.490	0.494	0.498	0.496		
J	1.174	1.184		1.178	1.178	1.178	1.177		
K	0.558	0.578		0.563	0.561	0.565	0.564		
L	1.174	1.184		1.178	1.178	1.178	1.177		
M	1.365	1.375		1.369	1.369	1.368	1.367		
N	2.495	2.505		2.497	2.497	2.499	2.497		
O	4.119	4.129		4.123	4.120	4.122	4.122		
P	0.115	0.135		0.127	0.125	0.125	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.245	0.250	0.246		
S	0.115	0.135		0.123	0.122	0.124	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.260	3.260	3.260	3.260		
V	0.230	0.250		0.239	0.231	0.220	0.235		
W	0.115	0.135		0.134	0.135	0.133	0.132		
X	0.307	0.312		0.309	0.309	0.309	0.309		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.368	0.368	0.367	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.624	0.626	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.242	0.245	0.244		
AE	1.500	1.520		1.510	1.508	1.511	1.508		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.244	0.250	0.245		
AI	2.000	2.020		w/19	w/19	w/19	w/19		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		

Accept/Reject

Measured by:	EP	Audited by:	TM
Date:	06/07/25	Date:	06/07/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SP

DART AEROSPACE LTD				Work Order:	27890
Description: Saddle, Aft Inboard				Part Number:	D2574
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4 8		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.748	1.746	1.746	1.745		
C	3.495	3.505		3.499	3.497	3.498	3.499		
D	1.745	1.755		1.748	1.746	1.746	1.745		
E	7.990	8.010		8.004	8.004	8.003	8.003		
F	0.490	0.510		0.496	0.496	0.495	0.498		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.502	0.498	0.500	0.499		
J	1.174	1.184		1.178	1.179	1.174	1.179		
K	0.558	0.578		0.564	0.566	0.566	0.563		
L	1.174	1.184		1.178	1.179	1.174	1.179		
M	1.365	1.375		1.369	1.368	1.366	1.369		
N	2.495	2.505		2.499	2.497	2.497	2.498		
O	4.119	4.129		4.123	4.123	4.123	4.123		
P	0.115	0.135		0.119	0.123	0.127	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.246	0.248	0.247	0.251		
S	0.115	0.135		0.123	0.120	0.120	0.120		
T	0.178	0.198		0.183	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.236	3.230	3.230		
V	0.230	0.250		0.246	0.238	0.239	0.236		
W	0.115	0.135		0.134	0.131	0.128	0.129		
X	0.307	0.312		0.309	0.309	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.364	0.366	0.368	0.361		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.622	0.624	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.246	0.246	0.248		
AE	1.500	1.520		1.508	1.508	1.509	1.509		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.266	0.260	0.260	0.265		
AH	0.240	0.260		0.249	0.248	0.250	0.248		
AI	2.000	2.020		WIA	WIA	WIA	WIA		
AJ	0.023	0.043		0.030	0.038	0.030	0.038		
Accept/Reject									

Measured by:	EN	Audited by:	JML
Date:	06/07/26	Date:	06/07/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	27 JML

DART AEROSPACE LTD				Work Order:	27890
Description: Saddle, Aft Inboard				Part Number:	D2574
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4 1/2		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.745	1.745	1.748	1.747		
C	3.495	3.505		3.500	3.499	3.499	3.500		
D	1.745	1.755		1.745	1.745	1.748	1.747		
E	7.990	8.010		8.001	8.003	8.002	8.003		
F	0.490	0.510		0.495	0.497	0.495	0.493		
G	0.257	0.262	DT8683	0.259	0.259	0.257	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.497	0.496	0.496	0.498		
J	1.174	1.184		1.180	1.179	1.174	1.174		
K	0.558	0.578		0.562	0.563	0.566	0.564		
L	1.174	1.184		1.180	1.179	1.174	1.174		
M	1.365	1.375		1.366	1.369	1.368	1.366		
N	2.495	2.505		2.496	2.497	2.497	2.497		
O	4.119	4.129		4.123	4.123	4.123	4.123		
P	0.115	0.135		0.124	0.125	0.124	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.248	0.248	0.247		
S	0.115	0.135		0.118	0.122	0.122	0.117		
T	0.178	0.198		0.1928	0.198	0.188	0.186		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.236	0.238	0.246	0.238		
W	0.115	0.135		0.133	0.133	0.134	0.133		
X	0.307	0.312		0.310	0.309	0.308	0.309		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.366	0.363	0.365	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.621	0.624	0.625	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.249	0.244	0.245		
AE	1.500	1.520		1.507	1.507	1.507	1.506		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.249	0.248	0.248		
AI	2.000	2.020		W1A	W1A	W1A	W1A		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP	Audited by:	CM
Date:	06/07/27	Date:	06/08/01

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SP

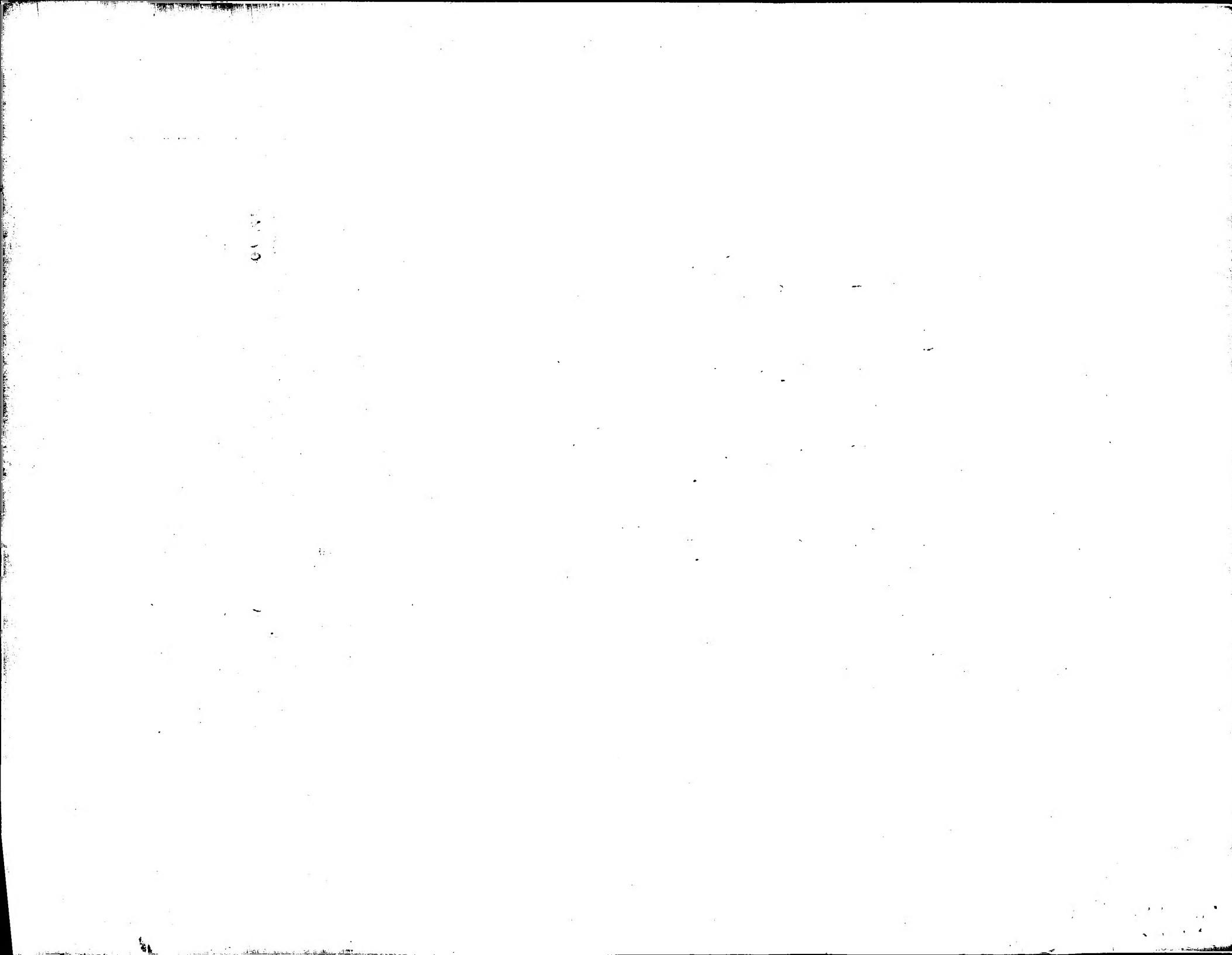
DART AEROSPACE LTD	Work Order:	27890
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4 <sup>b6</sup>		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.745	1.745	1.746	1.747		
C	3.495	3.505		3.499	3.499	3.498	3.497		
D	1.745	1.755		1.745	1.745	1.746	1.747		
E	7.990	8.010		8.004	8.003	8.002	8.001		
F	0.490	0.510		0.492	0.497	0.497	0.497		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.498	0.497	0.498		
J	1.174	1.184		1.179	1.177	1.179	1.180		
K	0.558	0.578		0.567	0.563	0.564	0.569		
L	1.174	1.184		1.179	1.177	1.179	1.179		
M	1.365	1.375		1.369	1.368	1.367	1.369		
N	2.495	2.505		2.495	2.493	2.497	2.496		
O	4.119	4.129		4.121	4.120	4.122	4.122		
P	0.115	0.135		0.126	0.125	0.124	0.123		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.248	0.247	0.246		
S	0.115	0.135		0.121	0.125	0.124	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.239	0.239	0.238	0.239		
W	0.115	0.135		0.134	0.130	0.139	0.129		
X	0.307	0.312		0.309	0.309	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.364	0.361	0.361	0.361		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.620	0.620	0.621	0.621		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.245	0.246	0.246		
AE	1.500	1.520		1.508	1.508	1.508	1.508		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.248	0.247	0.247		
AI	2.000	2.020		w/l7	w/l7	w/l7	w/l7		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP/S.G	Audited by:	TM
Date:	06/07/09	Date:	06/08/01

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SM



DART AEROSPACE LTD	Work Order:	27890
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

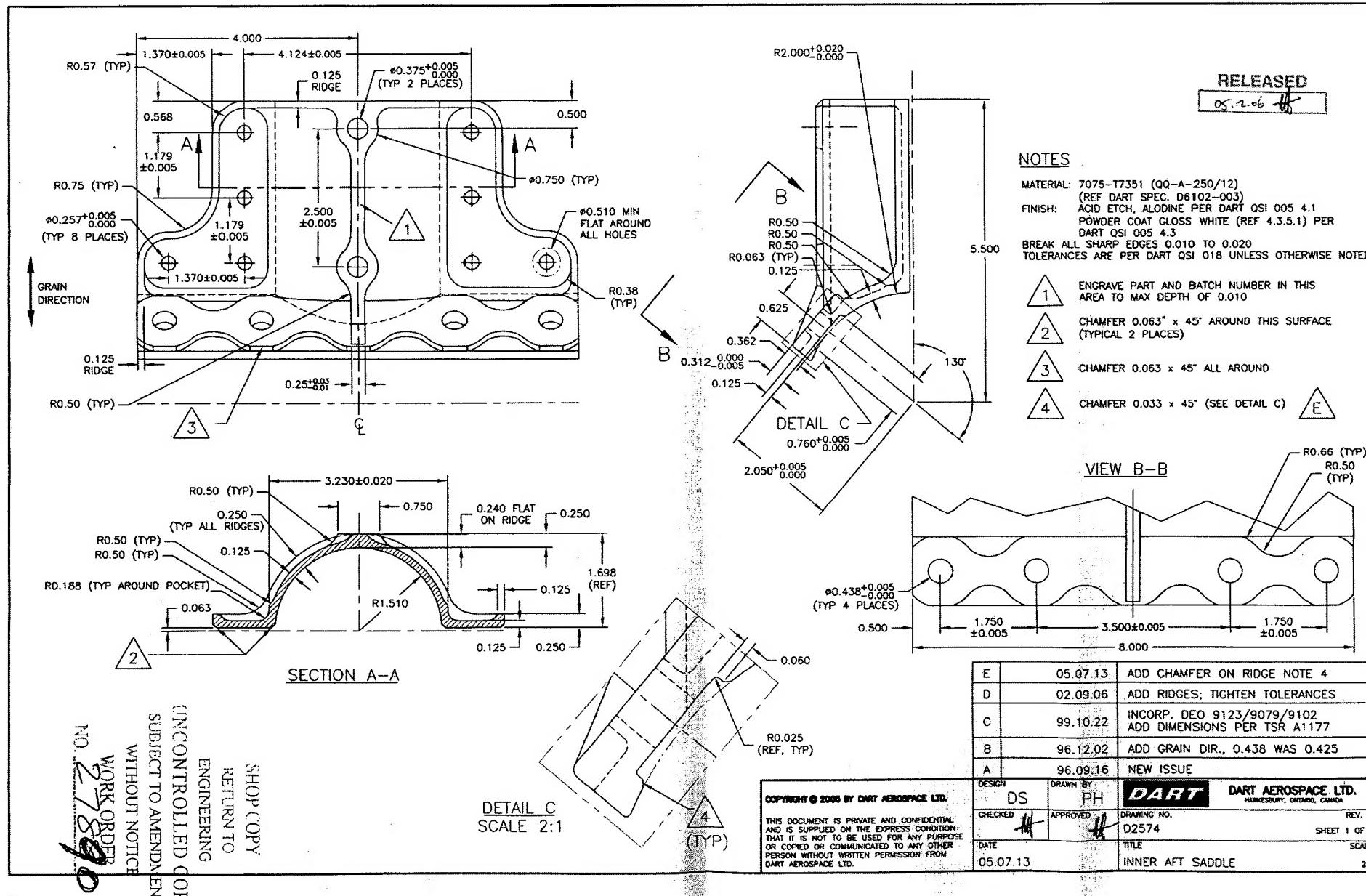
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.747	1.746	1.745	1.746		
C	3.495	3.505		3.499	3.498	3.497	3.498		
D	1.745	1.755		1.748	1.747	1.747	1.747		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		0.499	0.498	0.499	0.498		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	0.500	0.499	0.498		
J	1.174	1.184		1.179	1.179	1.180	1.179		
K	0.558	0.578		0.568	0.567	0.568	0.569		
L	1.174	1.184		1.179	1.180	1.179	1.180		
M	1.365	1.375		1.372	1.371	1.372	1.372		
N	2.495	2.505		2.499	2.497	2.496	2.497		
O	4.119	4.129		4.122	4.121	4.120	4.122		
P	0.115	0.135		0.125	0.124	0.123	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.232	0.231	0.249	0.248		
S	0.115	0.135		0.124	0.123	0.124	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.220	3.230	3.230	3.230		
V	0.230	0.250		0.241	0.241	0.248	0.241		
W	0.115	0.135		0.124	0.123	0.123	0.124		
X	0.307	0.312		0.316	0.310	0.316	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.364	0.364	0.365	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.625	0.624	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.241	0.240	0.241	0.241		
AE	1.500	1.520		1.510	1.511	1.512	1.513		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.248	0.247	0.246		
AI	2.000	2.020		W14	W14	W14	W14		
AJ	0.023	0.043		0.032	0.030	0.030	0.030		

Accept/Reject

Measured by:	J-G
Date:	06/07/10

Audited by:	JK
Date:	06/08/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
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WORK ORDER  
NO. 27890

**Peter Hum**

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**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** July 24, 2006 2:55 PM  
**To:** 'Peter Hum'  
**Subject:** RE: D2574 B27890 flat dimension

I think this is an acceptable deviation.

David

---

**From:** Peter Hum [mailto:[phum@dartaero.com](mailto:phum@dartaero.com)]  
**Sent:** Monday, July 24, 2006 12:16 PM  
**To:** 'David Shepherd'  
**Subject:** D2574 B27890 flat dimension

David,

In machining the D2574 saddle, the thickness of the crosstube bore near the flat is 0.220 and the nominal dimension is 0.240. I've attached a sketch to illustrate the location.

Is this deviation acceptable?

Peter <<...>>